

Work Order ID 131704

131704

Page 1

Tuesday, April 21, 2015 1:47:11 PM

Item ID: D2364 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Deck Plate Fwd
 Start Date: 4/20/15 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 4/20/15 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 150423 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2364	Rev F								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2364 Dwg Rev: <u>F</u> Prog Rev: <u>F</u> 2- Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
38
9-88
APR 29 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause		FAULT CATEGORY																					
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Work Order ID 131704

131704

Page 2

Tuesday, April 21, 2015 1:47:11 PM

Item ID: D2364

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Deck Plate Fwd

Start Date: 4/20/15

Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/20/15

Req'd Qty: 4.00

4

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
StampDAS
36
9-89

130

130

Small Fab

Small Fab

Memo

0.00

0.00

1- counter sink holes as per dwg D23642- deburr if necessary

5X

15/04/30

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

5

DAS
38
9-89

APR 30 2015

150

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

5

x

02/15/05/03

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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131704

Page 4

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MLJ

MAY 11 2015

MLJ MAY 11 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Misidentified ☐	Past Due ☐																								

Picklist Print

Tuesday, April 21, 2015 1:47:10 PM

Page 1

Work Order ID: 131704

131704

Parent Item: D2364

D2364

Parent Item Name: Deck Plate Fwd

Start Date: 4/20/15

Required Date: 4/20/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV. E00.06.26Removed P/O for powder coatEC
IPP Rev:F Now On Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased		No		100	sf	198.6680	0.6469	2.72379			

M2024T3S 063

2024-T3 .063 sheet

DC 15/04/29

Location

Loc Qty

Loc Code

MAT022

198.668

m127866

16

m130525

182.668

3.6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
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OTHER : ☐									

DART AEROSPACE LTD		Work Order: 131704
Description: Litter Deck Plate Kit (350)		Part Number: D2364
Inspection Dwg: D2364 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.624	+/-0.010	6.629	/		Vide-02	
Ø0.171	+0.005/-0.000	Ø.170	/		Vide-01	
0.354	+/-0.010	.353	/		Tape	
11.242	+/-0.010	11.246	/			
3.031	+/-0.010	3.037	/			
1.903	+/-0.010	1.904	/			
1.128	+/-0.010	1.129	/			
0.354	+/-0.010	.355	/			
1.340	+/-0.005	1.337	/			
2.326	+/-0.010	2.321	/			
3.312	+/-0.010	3.309	/			
4.298	+/-0.010	4.291	/			
5.284	+/-0.010	5.279	/			
6.151	+/-0.010	6.151 6.155	/			
6.270	+/-0.010	6.269	/			
0.354	+/-0.010	.355	/			
3.031	+/-0.010	3.034	/			
Ø0.656	+0.005/-0.000	Ø.655	/			
5.003	+/-0.010	5.003	/			
4.605	+/-0.010	4.602	/			
1.776	+/-0.010	1.777	/			
0.980	+/-0.010	.981	/			
4.487	+/-0.010	4.491	/			
7.192	+/-0.010	7.196	/			
7.567	+/-0.010	7.573	/			
7.942	+/-0.010	7.948	/			
Ø0.191	+0.005/-0.000	Ø.190	/			
Ø0.197	+0.005/-0.000	Ø.197	/			
11.145	+/-0.010	11.151	/			
12.181	+/-0.010	12.185	/			
11.378	+/-0.010	11.383	/			
11.776	+/-0.010	11.782	/			
12.173	+/-0.010	12.175	/			
4.690	+/-0.010	4.687	/			
0.250	+0.005/-0.000	.252	/			
3.141	+/-0.010	3.142	/			
0.171	+0.005/-0.000	.175	/			

Measured by: <i>DC</i>	Audited by: <i>38</i>	Prototype Approval:	N/A
Date: 15/02/29	Date: APR 29 2015	Date:	N/A

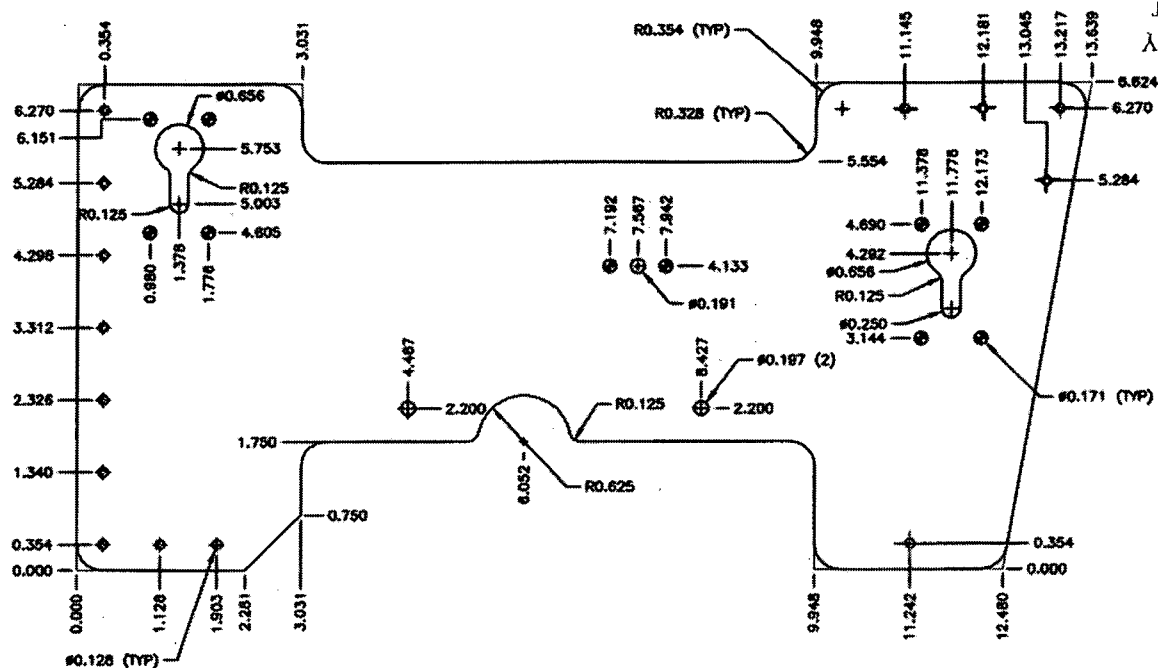
Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	08.05.28	7.567 dimension revised	KJ/DD	

QA COPY ISSUED

DECLASSIFIED
98/06/22 KE

1504-23-131704 MLO

COUNTER SINK HOLES:
 ♦ C'SINK Ø0.225 x 100' (UPDATED FROM 9 TO 14 HOLES BY DS 99.03.01 TO CORRECT CAD ERROR)
 ♦ C'SINK Ø0.308 x 100'



MATERIAL: 2024-T3 (QQ-A-250/5) 0.063-0.071 THICK
FINISH: POWDER COAT BLACK CRINKLE (4.3.5.3) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2364	REV. F
DATE 98.06.19		TITLE LITTER DECK PLATE, 350	SHEET 1 OF 1
A	95.01.14	NEW ISSUE	
B	95.02.09	MOVED KEYWAY	
D	95.03.06	0.191 WAS 0.197	
E	95.10.06	GEOMETRY CHANGES	
F	98.06.19	0.063--0.071 THICK WAS 0.071 (TSR A371)	